

Work Order ID 128250

Tuesday, January 13, 2015 1:36:19 PM

128250

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Item ID: D4150-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Arm

Start Date: 1/13/2015 Start Qty: 12.00

12

Cust Item ID:

Required Date: 1/20/2015 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: MCS Date: 15-01-14

Tooling: _____ Date: _____

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4150	B
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100 Cut blanks as per folio

0.00

100

Bandsaw

Memo

0.00

Jeaspa Bandsaw

3.950" LONG

12ØDAS
20
9-8915-01-14

110

0.00

110

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOLI FA943 AND DWG

FOLIO REV: BDWG REV: B

DEBURR

12ØDAS
44
9-8915/01/17

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Setup Start *NS1*

Revision ID:

Item Name: Arm

Stop *NS2*

Cust Item ID:

Customer:

Reference:

Run Start *NR1*

Stop ***NR2***

**Insp.
Stamp**

0.00

180

QC

Memo

0.00

Quality Control

MLS 15-01-22

MS-1-21

Picklist Print

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Work Order ID: 128250

128250

Parent Item: D4150-1

D4150-1

Parent Item Name: Arm

Start Date: 1/13/2015

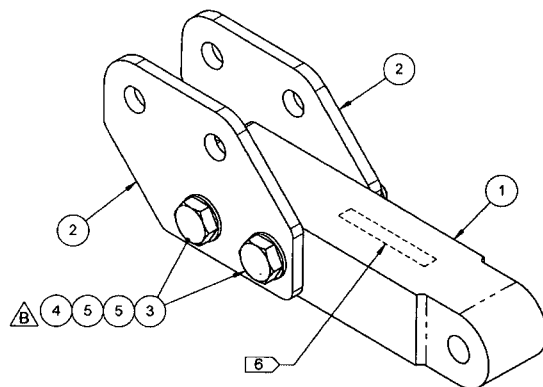
Required Date: 1/20/2015

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303B0.750X1.500		Purchased		No		100	f	10.6500	0.333333	4			
M303B0 750X1 500										**	<u>4.166</u>	DAS	20
303 BAR .750" X 1.500"												9-89	15-01-16
						<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>			
						MAT008		10.65					
						m130561		10.65		<u>4.166</u>			



D4150-041 ATTACHMENT ARM ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4150-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.82 lbs

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4150-041	ATTACHMENT ARM ASSY
1	1	D4150-1	ARM
2	2	D4150-3	ARM PLATE
3	1	AN3C13A	BOLT
4	1	MS21043-3	NUT
5	2	NAS1149C0332R	WASHER

REPLACED
QTY(3) MS20615-4M20 WITH QTY(2) EACH
AN3C13A, MS21043-3 AND QTY(4) NAS1149C0332R
WASHER (ZN D3-1); Ø0.191 2 PL REPLACES Ø0.129 3 PL
(ZN C6-2, C7-2, B4-3 & B5-3)
REASON: SEE TR-D350-607-2 REV. B.

128250-MLJ
1501-14

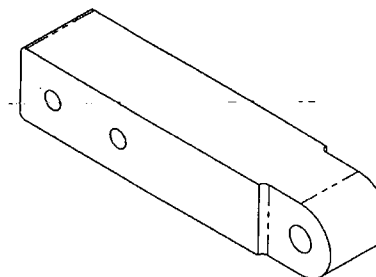
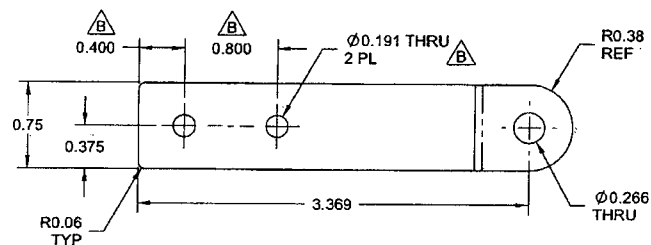
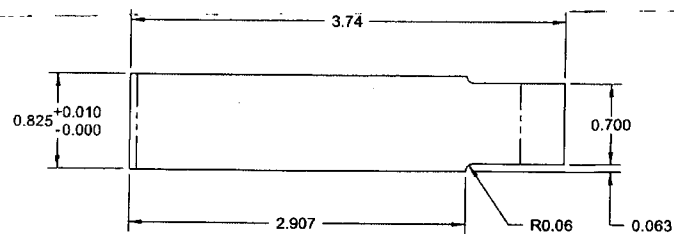
RELEASED
2010-07-16

B	REPLACED QTY(3) MS20615-4M20 WITH QTY(2) EACH AN3C13A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN C6-2, C7-2, B4-3 & B5-3) REASON: SEE TR-D350-607-2 REV. B.	MB	10.07.08
A	NEW ISSUE	MB	10.08.18
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.07.08		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4150** REV. B
SHEET 1 OF 3
TITLE **ATTACHMENT ARM ASSY** SCALE NTS

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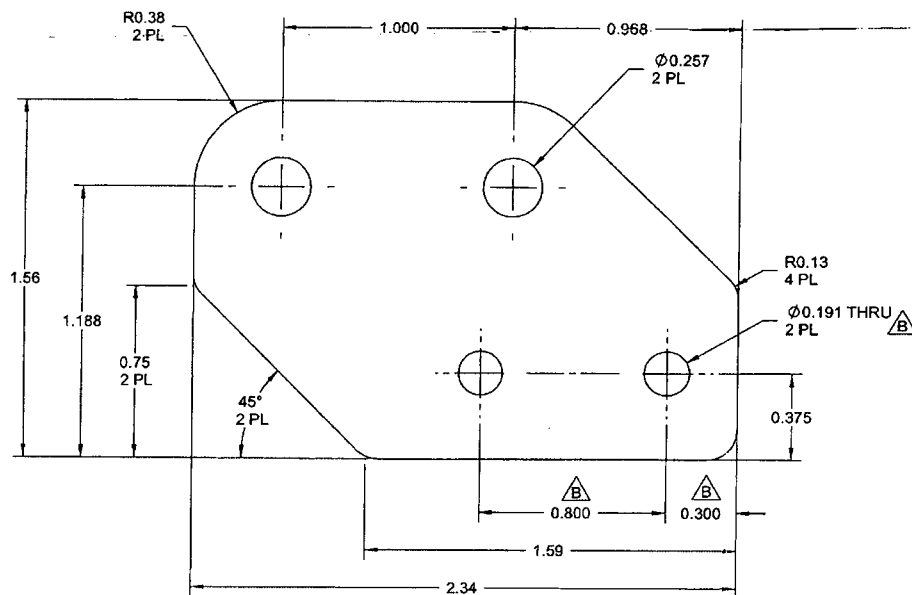
D4150-1 ARM

RELEASED
2010-07-16

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
REF DART SPEC M304B OR M303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.60 lbs

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MFG. APPR.		SHEET 2 OF 3	
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DE APPR.		ATTACHMENT ARM ASSY	NTS
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D4150-3 ARM PLATE

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2010-07-16

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" THICK SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.10 lbs

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MFG. APPR.		D4150	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		ATTACHMENT ARM ASSY	
DATE	10.07.08	NTS	

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